

605P

1. (Amended) A method for manufacturing a release-controlled pipe which mainly comprises a plurality of steps which are:

~~Mixing Formulation:~~ mixing a plurality of elastomer pellets and a binder ~~being mixed to~~ said formulation, wherein said elastomer pellets occupy comprise 60 to 80 percent of the mixture and can be rubber material such as waste tires, which and wherein said binder occupies comprises 40 to 20 percent of the mixture and can be resin material;

~~First Hot Melt Extrusion and Cooling:~~ pouring said formulation ~~being poured~~ into a first melt extruder to form a rod-like extrudate, and then cooling said rod-like extrudate being cooled through a conveyor and a cooling unit;

~~Grinding and Blending:~~ grinding said rod-like extrudate being ground into pieces pellets, then ~~being placed~~ placing a portion of the pellets into a water-filled container and another portion of the pellets into a dry container thus producing dry ground pellets and wet ground pellets for collecting separately;

~~Second Hot Melt Extrusion:~~ mixing a mixture of dry ground pellets and wet ground pellets which were soaked in water, with a small amount of lubricant such as stearic acid, ~~being poured and pouring the mixture~~ into a secondary hot-melt extruder and using a pipe die head ~~being used for shaping to extrude and shape~~ a release-controlled pipe;

Cooling: ~~said cooling the extruded release-controlled pipe extruded by means of said pipe die head being cooled and having a fixed shape through a with water tank and a sprayer to fix the shape of the pipe, and then being gathered gathering the pipe using by a winder.~~

2. (Amended) A method for manufacturing a release-controlled pipe as recited in claim 1, wherein said ground pellets are soaked in said water-filled container for more than one day ~~to get enough water content.~~